

Work Order ID 144020

144020

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March 30, 2016 10:01:46 AM

Item ID: D4385-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Placard

Stop

NS2

Start Date: 4/8/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/15/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: SH Date: 20160330 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4385	A								

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 31928
 Manufacture as per Dwg D4385
 Possible Supplier: Studio Lettrage
 Material release note is required

10 APR 04 2016 DAS
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material release note is attached

10x SP 16-04-14

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

(10) DAS
38
9-89

APR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144020

144020

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March 30, 2016 10:01:46 AM

Item ID: D4385-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Placard
 Start Date: 4/8/2016 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 4/15/2016 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>Stores</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	***ONE YEAR EXPIRED DATE FROM RECEIVING: <u>APR 15 2017</u> ***								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

10 ML 16-04-15
 ML APR 15 2016
 Lm 16/4/15
 ML APR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

March 30, 2016 10:01:51 AM

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Work Order ID: 144020

144020

Parent Item: D4385-1

D4385-1

Parent Item Name: Placard

Start Date: 4/8/2016

Required Date: 4/15/2016

Start Qty: 10.00

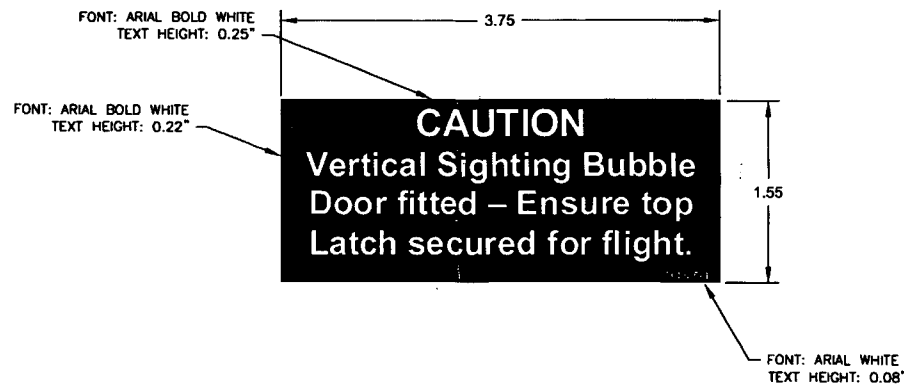
Required Qty: 10.00

Comments: IPP Rev:A 11.04.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4385-1P		Purchased	No			110	Each	0.0000	1	10			
D4385-1P									**				

Placard

10 x 80/6-04-14



D4385-1 PLACARD

NOTES:

- 1) MATERIAL: MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WHITE LETTERS ON RED ADHESIVE BACK VINYL

20160330

SW 144020

RELEASE
2011-04-06
DM

A		NEW ISSUE		RF	11.03.31
DESIGN		RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		RF			
CHECKED				DRAWING NO.	REV. A
MFG. APPR.				D4385	SHEET 1 OF 1
APPROVED				TITLE	SCALE
DE APPR.				PLACARD	NTS
DATE				11.03.31	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31928

Purchase Order Date 4/4/2016

PO Print Date 4/4/2016

Page Number 1 of 2

Order From :
STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

VC-STU001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

APR 05 2016

Contact Name
Vendor Phone 613 632 5449

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4385-1P ✓ AS PER DWG D4385 REV. A B144020	Placard ✓	4/11/2016 Yes 4/11/2016		10.00 ✓ Each	\$8.00	\$80.00
Line Total:							\$80.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	4/11/2016 No 4/11/2016		1.00 ✓	\$0.00	\$0.00
Procurement Quality Clauses A005 RIGHT OF ENTRY A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER) A013 SHELF LIFE CONTROLLED MATERIAL; 80% SHELF LIFE REQUIRED AT RECEIPT A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS							

Sp/6-at-14

Note:

4/4/2016

STUD!O

210 Main Street West
Hawkesbury, ON K6A 2H6
Phone # 613-632-2001

Invoice

Date	Invoice #
4/14/2016	42098

Invoice To

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury
Ontario
K6A 1K7

Ship To

P.O. No.	Terms	Rep	Ship	Via	F.O.B.	Project
31928						

Quantity	Item	Description	Price Each	Amount
10	4005	D4385-1P. Attn: Chantal Ref: 17501 <i>Sp 16-04-14</i>	8.00	80.00

Subtotal \$80.00

Sales Tax \$10.40

Total \$90.40

Thank you for your business.

******CERTIFICATE of CONFORMITY******

Customer:

Studio de Lettrage

Purchase Order N°:

31928

Packing Slip N°:

wo# 17501

Part N°:

Serial N°:

Description:

D4385-1P.

Quantity:

10

Certification:

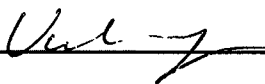
We hereby certify that:

1. The above listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

Avery

APPROVAL: Valerie Yang

Signature: 

Title: office administrator

DATE:

April 14.16.

PRODUCT DATA SHEET



Avery® IPM™ 2031

issued: 01/04/2005

Introduction

Avery® IPM™ 2031 is a high quality pressure-sensitive vinyl film, designed for use on wide format inkjet printers. Avery® IPM™ 2031 has excellent printing properties, allowing crisp print quality with bright and vibrant colours. Avery® IPM™ 2031 offers rapid ink drying and a water-resistant material. It combines good adhesion during its life and easy removal afterwards.

Description

Facefilm: 80-micron premium white calendered, topcoated vinyl.
Adhesive: removable, acrylic based
Backing paper: one side coated kraft paper, 140 g/m²

Features

- Excellent printability
- Vibrant and bright colours
- Crisp print quality
- Spray water resistant with specific pigmented inks
- Good adhesion, excellent removability
- Warranty on outdoor durability

Recommendations for use

A wide variety of full-colour graphics for indoor - and **short/medium term outdoor** applications such as posters, murals, displays, exhibition stands, vehicle graphics etc. Avery® IPM™ 2031 is suitable for application to a wide variety of substrates and will remove cleanly for up to 1 year after application.

IPM media should be handled with care as any surface contamination may affect the print quality. Media should be processed in an environment of 15-25°C and 30-70% relative humidity. After drying, the finished prints should be wrapped in polyethylene film and despatched flat or rolled with the printed side facing outwards. To protect prints against water, UV/light and abrasion, overlamination with a clear film is recommended. For specific details of Avery® DOL combinations, refer to "Technical Bulletin 5.3. Recommended combinations of Avery® Overlaminates and Avery® Digital Print Media"

Always test your combination of Avery® IPM™ medium, inkjet printer and inks prior to commercial use.

Compatibility

Avery® IPM™ 2031 is compatible with a broad selection of inkjet printers, when printing with pigmented, water based inks. For specific details refer to "Technical Bulletin 5.6 Avery Dennison Inkjet Print Media - Printer compatibility".

Durability:

Avery® IPM™ 2031 is warranted for outdoor use in conjunction with pigmented outdoor inks from HP, Encad and Colorspan. The warranted period varies from type of application and type of overlaminate from 18 months up to 5 years. For full details, see our Avery® IPM™ Outdoor warranty.



www.averygraphics.com

Graphics Division
Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538

PRODUCT CHARACTERISTICS

Avery® IPM™ 2031

Physical properties

Features	Test method ¹	Results
Caliper, facefilm	ISO 534	80 µm
Gloss	ISO 2813, 20°	1%
Dimensional stability	DIN 30646	0.3 mm. max
Adhesion, initial	FINAT FTM-1, stainless steel	180 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	260 N/m
Flammability		Self extinguishing
Accelerating ageing	DIN 53587, 500h exposure	No negative impact on film
Shelf life	Stored at 22° C/50-55 % RH	Performance
Removability		2 years
Not when applied to: Nitro-cellulose paints, ABS, Polystyrene, certain types of PVC		up to 1 year
Durability ²	Overlaminated with DOL 4300	5 years
	Overlaminated with DOL 1000, DOL 1100 with overlaps	3 years
	Overlaminated without overlaps for static applications only	2 years
	Without overlaminate and used for static, Non-abrasive application ONLY	18 months

Only when printed with ENCAD GO, HP and Colorsplan pigmented inks and when properly applied in accordance with our application instructions. Only applicable for vertical exposure.

Temperature range

Features	Results
Application temperature	Minimum: +10°C
Service temperature	-20°C to +80°C

Important
Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use. All technical data are subject to change. In case of any ambiguities or differences between the English and foreign versions of these Conditions, the English version shall be controlling.

Warranty
Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing. All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods
More information about our test methods can be found on our website.

2) Durability
The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



www.averygraphics.com

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